

Date: Wednesday, 08/10/2008 3:19:09 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASSEMBLY
Job Number	: 42514		
Estimate Number	: 13280		
P.O. Number	:	Part Number	: D3674041
This Issue	: 08/10/2008 S.O. No. :	Drawing Number	: D3674 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 08/10/2008 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 40122	Material	:
Written By	:	Due Date	: 25/10/2008
Checked & Approved By	: <u>JLD 08.10.08</u>	Qty:	40 / 24 Um: Each
Comment	: Est Rev:A New Issue 08-04-25 JLM Verified By:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M174B1250X02000	17-4 SS Bar 1.250 x 2.00
Comment: Qty.: 0.5775 f(s)/Unit Total : 13.8600 f(s) Material: 17-4 SS Bar per AMS 5604/5643 (M17-4-B1.250x02.000) Identify for D3674-1 Batch: <u>M109457</u>		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blanks: (1.250" x 2.000") 5.400" long.		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine D3674-1 as per Folio FA732 and Dwg D3674 Identify as D3674-1 2-Deburr 3-Scribe batch number		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3674-041 PAR #: N/A. Fault Category: Prod/Machined Parts NCR: (Yes) No DQA: LD Date: 08/10/27
 (D412-648-031-032) Resolution: SCRAP Disposition: SCRAP. QA: N/C Closed: KG Date: 08/11/11

NCR: 42514		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/10/27	# 3.0	1 parts scrap Rougher pulled out of holder causing Dim. 5.139 and 4.880 to be 0.100" too short.	<u>DB</u> <u>enr</u>	SCRAP and Destroy and Replace Qty <u>(x2)</u> B# <u>109457</u>	<u>DJP</u> 08/10/27	<u>C</u> 08/10/27	<u>DB</u> <u>enr</u>	<u>S</u> 08/10/27
		R.L. Rougher Pulled out of holder. Tooling.						<u>S</u> 08/10/27

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 42514

Part Number: D3674041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ml 08/10/27

(40)

6.0

D312121

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-21

Bolt

B 40284 (10x)

B 40351 (30x)

7.0

D3121241

Bearing Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-241 Bearing Ass

B 39948 (37x)

B 39948 (37x)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble D3674-041 as per Dwg D3674

08/10/28 (40)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/28 (40) counter

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

08/10/28

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/29

Job Completion



u 08/10/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 4254
Description: Bracket		Part Number: D3674-1
Inspection Dwg: D3674	Rev: A	Page 1 of 2

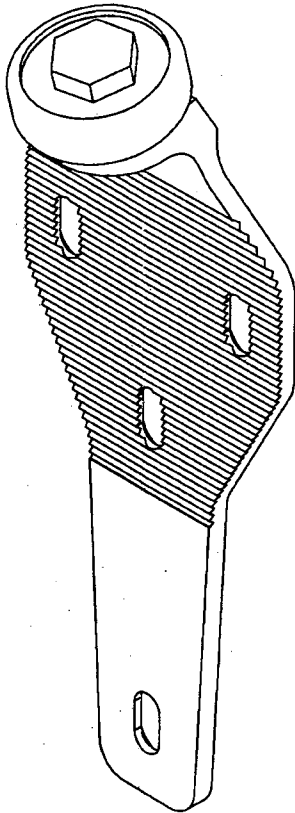
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.960	+/-0.010	1.962	✓			
0.750	+/-0.010	0.750	✓			
0.605	+/-0.010	0.605	✓			
3.380	+/-0.010	3.374	✓			
2.430	+/-0.010	2.424	✓			
0.380	+/-0.010	0.374	✓			
0.73	+/-0.030	0.730	✓			
0.95	+/-0.030	0.947	✓			
2.140	+/-0.010	2.140	✓			
2.030	+/-0.010	2.030	✓			
4.718	+/-0.010	4.716	✓			
4.590	+/-0.010	4.585	✓			
0.863	+/-0.010	0.868	✓			
0.130	+/-0.010	0.127	✓			
4.600	+/-0.010	4.600	✓			
4.880	+/-0.010	4.880	✓			
5.139	+/-0.010	5.134	✓			REF
R0.25	+/-0.030	0.250	✓			
0.080	+/-0.010	0.080	✓			
0.300	+/-0.010	0.300	✓			
30°	+/-0.5°	30°	✓			
Ø0.573	+/-0.010	0.573	✓			
0.720	+/-0.010	0.725	✓			
0.345	+/-0.010	0.345	✓			
Ø0.392	+0.002/-0.000	0.393	✓			
2.173	+/-0.010	2.173	✓			
3.135	+/-0.010	3.135	✓			
3.963	+/-0.010	3.963	✓			
4.365	+/-0.010	4.365	✓			
0.664	+/-0.010	0.664	✓			
100°	+/-0.5°	100°	✓			
0.076	+/-0.010	0.080	✓			
0.200	+/-0.010	0.200	✓			
0.200	+/-0.010	0.200	✓			
R0.10	+/-0.030	0.094	✓			
0.032	+0.000/-0.010	0.030	✓			

8 7 6 5 4 3 2 1

QTY -041	PART NUMBER	DESCRIPTION
X	D3674-041	ROLLER BRACKET ASSEMBLY
1	D3121-21	BOLT
1	D3121-241	BEARING ASSEMBLY
1	D3674-1	BRACKET





D3674-041 BRACKET ASSEMBLY

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: N/A
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 0.23 lbs
8) TORQUE D3121-21 BOLT 15-25 in lbs (1.7-2.8 Nm)

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WORK ORDER

RELEASED 42514
08-06-26

A	NEW ISSUE	AJS	08.03.26
REV.	DESCRIPTION		DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	ASB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3674	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		ROLLER BRACKET ASSEMBLY	NTS
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2

1

D

D

C

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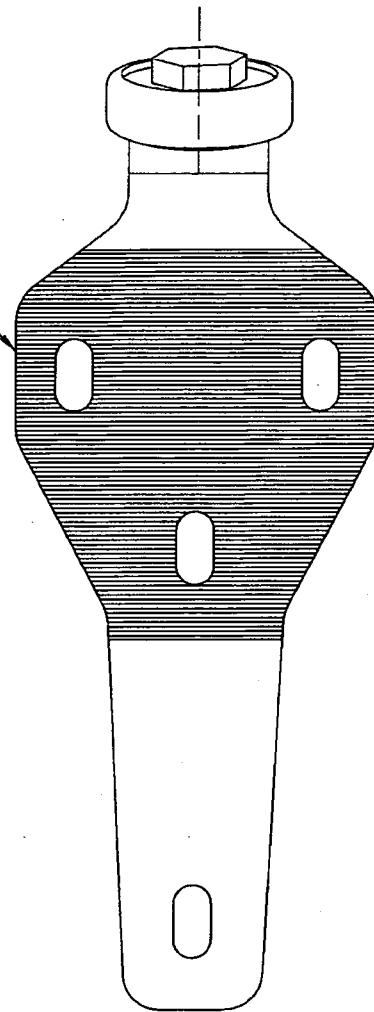
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B

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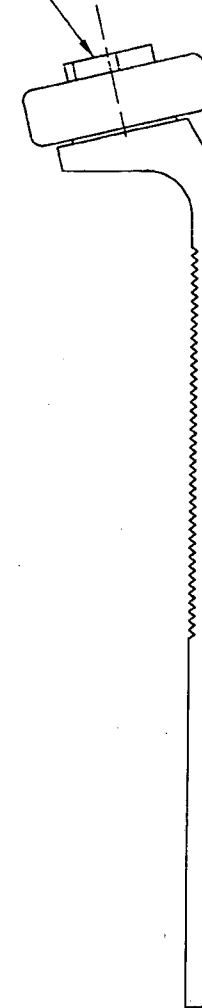
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D3674-1 BRACKET

**D3674-041 BRACKET ASSEMBLY**

D3121-21 BOLT

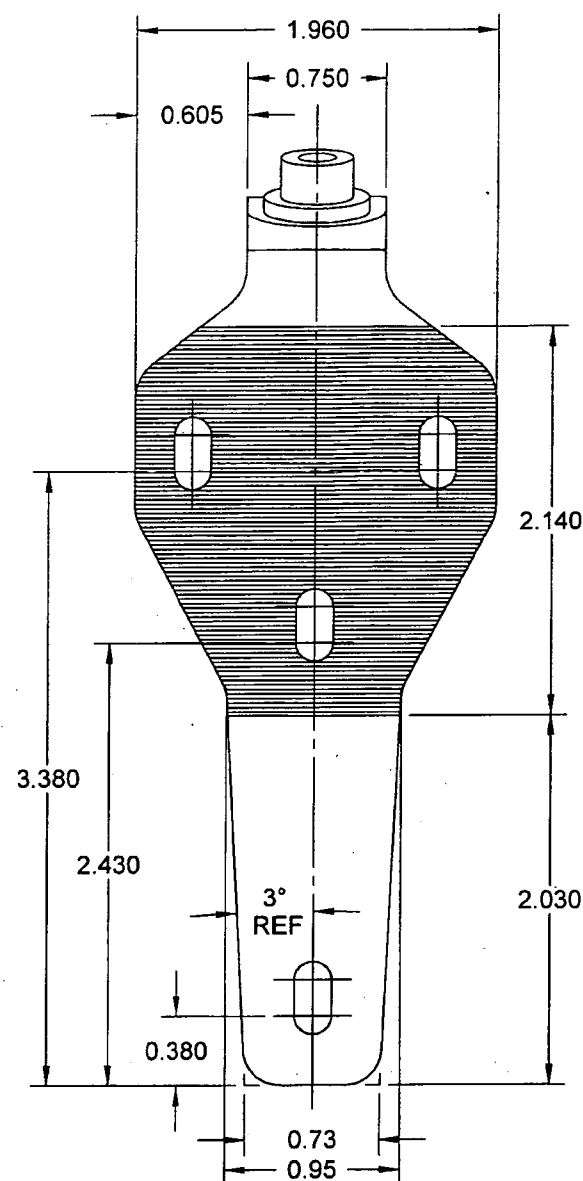
D3121-241 BEARING ASSEMBLY



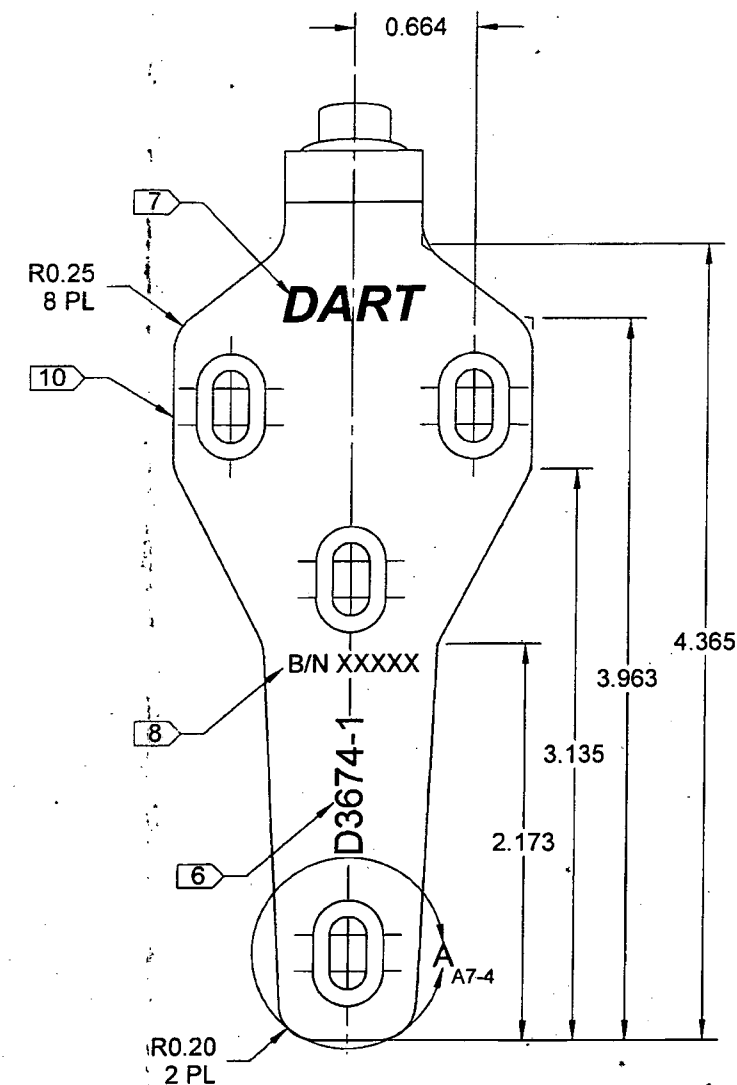
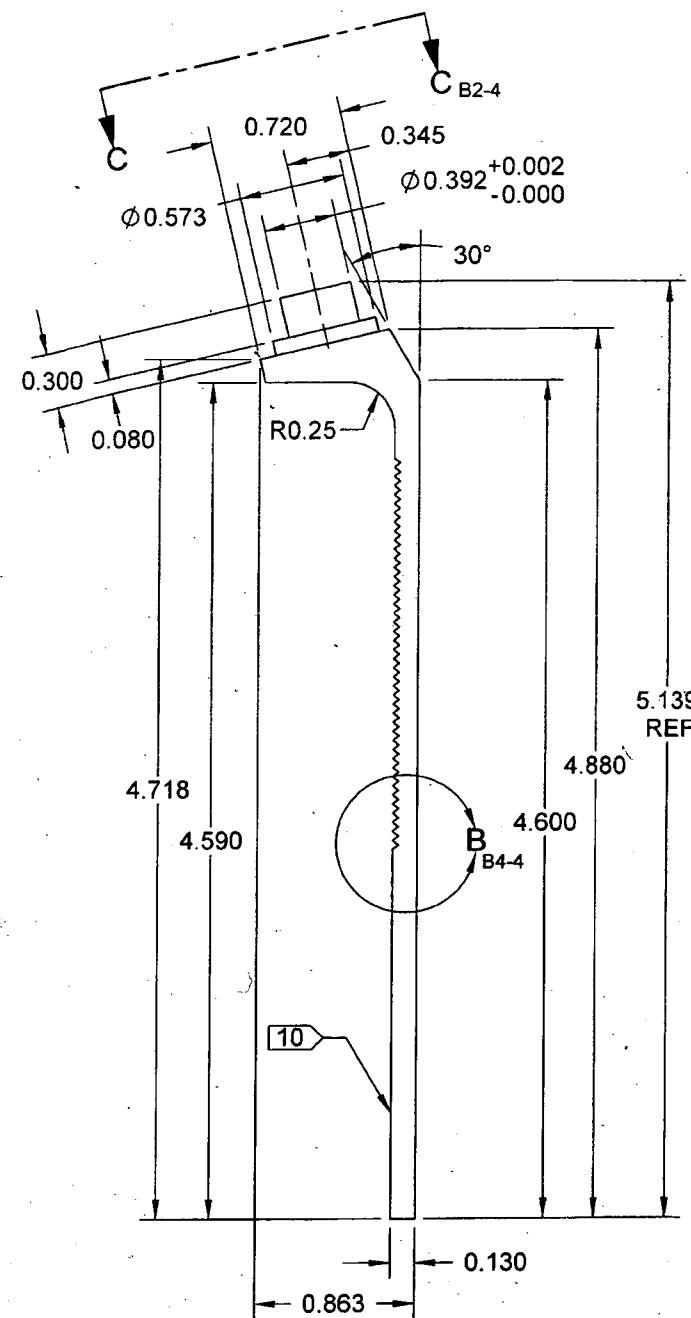
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08-08-26

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MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 4	
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D3674-1 BRACKET



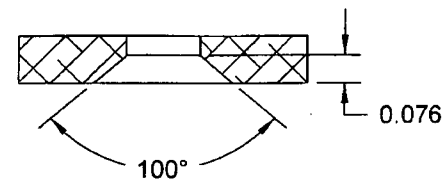
NOTES:

- 1) MATERIAL: 17-4 PH, STAINLESS STEEL BAR
PER AMS 5604/5643
GRAIN DIRECTION MUST BE ALONG THE LENGTH OF THE BRACKET
MINIMUM YIELD TENSILE STRENGTH = 100 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 150 ksi
(REF. DART SPEC. M17-4-B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3674-1" WITH 0.15 HIGH LETTERS TO A
MAX DEPTH OF 0.010 IN AREA SHOWN.
- 7) IDENTIFICATION: ENGRAVE DART LOGO WITH 0.20 HIGH LETTER TO A
MAXIMUM DEPTH OF 0.010 IN AREA SHOWN
- 8) IDENTIFICATION: SCRIBE DART B/N USING VIBRATING STYLUS
- 9) WEIGHT: 0.03 lbs
- 10) BASIC PROFILE OF D3674-1 BRACKET TAKEN FROM D3121-141 REF.

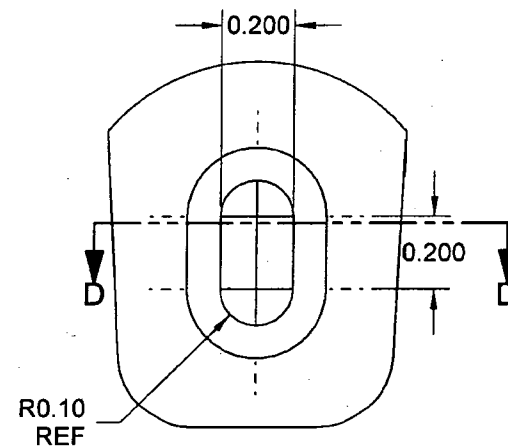
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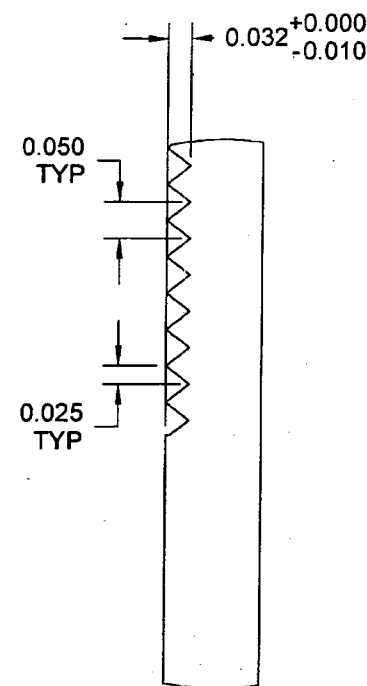
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MFG. APPR.		D3674	SHEET 3 OF 4
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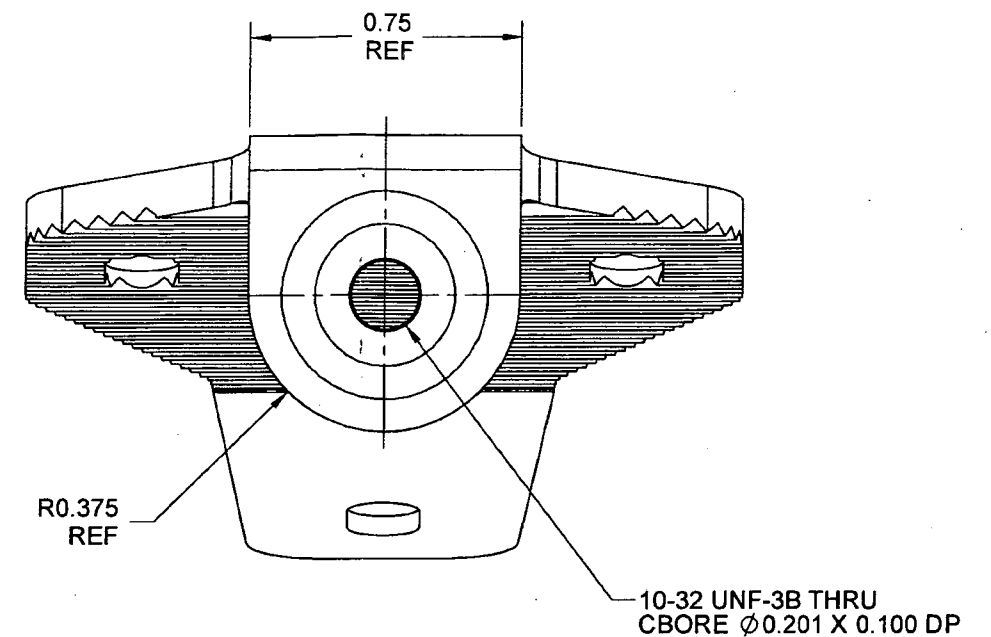
SECTION D-D



**DETAIL A B2-3
SCALE 2X
(SLOT DETAIL 4PL)**



**DETAIL B C4-3
SCALE 4X
(RIDGE DETAIL)**



**VIEW C-C D3-3
SCALE 2X**

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MFG. APPR.		D3674	SHEET 4 OF 4
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